

Work Order ID 63405

Friday, October 29, 2010 7:23:20 AM



Page 1

Item ID: D412-698-019

Accept



Setup Start



Revision ID:

Item Name: Bearing Overhaul

Stop



Start Date: 10/29/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *mk*

Date: 10-10-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-698-019

CHG001

8/10/29

H for BG 10-10-29

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10/10/29

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/10/10/29

(72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63405

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Item ID: D412-698-019

Accept

Revision ID:

Item Name: Bearing Overhaul

Start Date: 10/29/2010 Start Qty: 1.00

Required Date: 10/29/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D412-698-019 Location: 31A □ PPP Rev: A

0.00

0.00

10/29/10 20

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/10/29 2

10-10-29

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, October 29, 2010 7:23:19 AM

Page 1

Work Order ID: 63405

Parent Item: D412-698-019

Parent Item Name: Bearing Overhaul



Start Date: 10/29/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B 05-10-12 Pick List Revised KJ/JLM
IPP Rev:C 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3121-21		Manufactured	No				Each	52.0000	7	1717		10/10/2010	
Bolt													

Location	Loc Qty	Loc Code
ST235	52	
57376	1	
61839	51	

D3121-241		Manufactured	No				Each	40.0000	5	14		10/10/2010	
Bearing Assembly													

Location	Loc Qty	Loc Code
ST235B	40	
55005	2	
59774	6	
61641	9	
61840	3	
62211	20	

D3137-3		Manufactured	No				Each	5.0000	1	11		10/10/2010	
Guide													

Location	Loc Qty	Loc Code
ST235B	5	
62560	5	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 63405



Parent Item: D412-698-019



Parent Item Name: Bearing Overhaul

Start Date: 10/29/2010

Required Date: 10/29/2010

Start Qty: 1.00

Required Qty: 1.00

D3137-5

Manufactured No

Each

5.0000

1



Washer



10/10/09 sl

Location

Loc Qty

Loc Code

ST235B

5

61701

5

Each

12.0000

2

D3183-045

Manufactured No



Bearing Assembly



2 10/10/09 sl

Location

Loc Qty

Loc Code

ST236

12

62216

11

63006

1

Each

53.0000

1

MS24694-S101

Purchased

No



Screw



10/10/09 sl

Location

Loc Qty

Loc Code

ST290A

53

110363

53

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: E

Date: 08.05.01